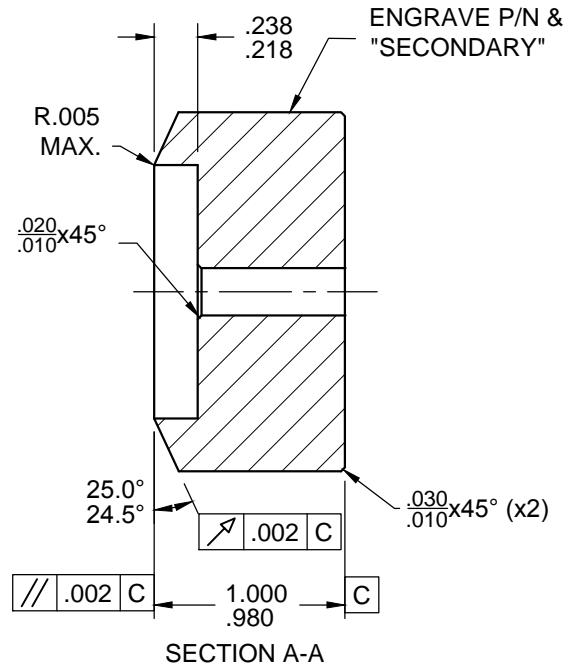
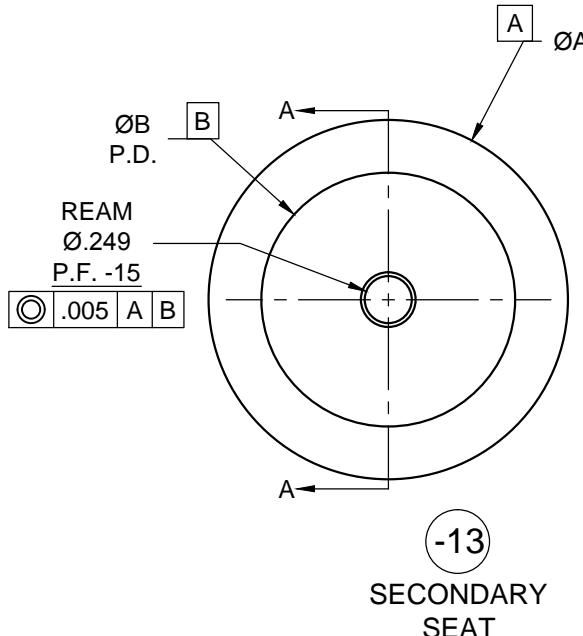


NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

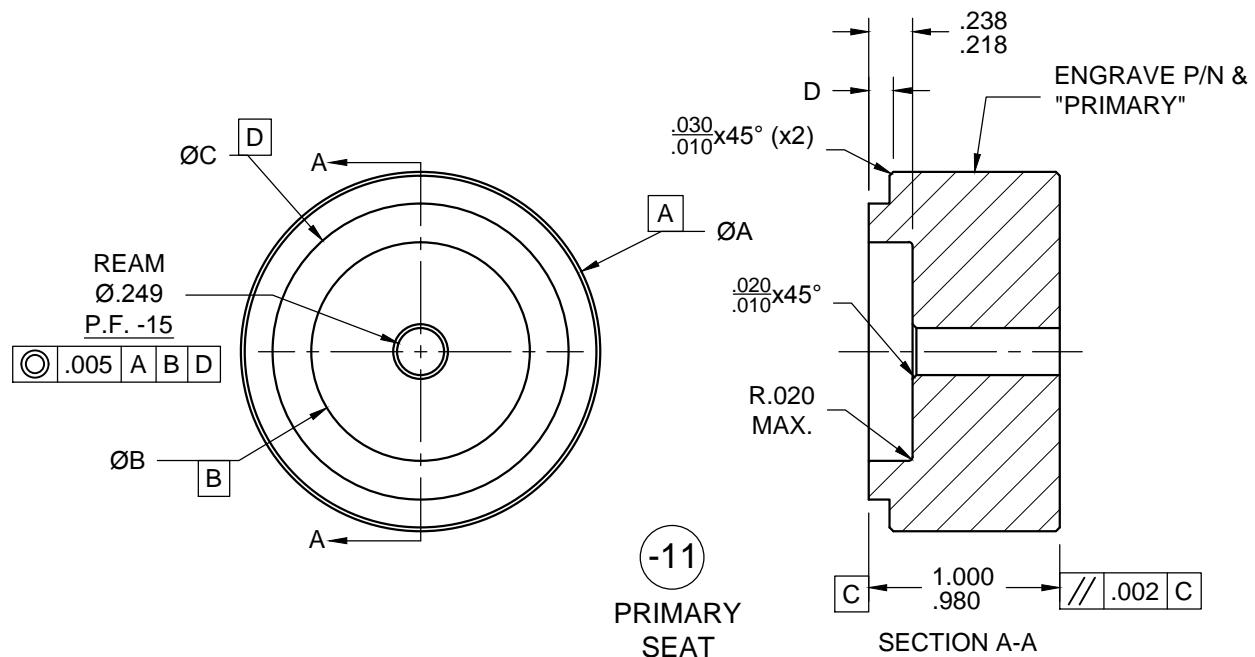
 RED BARN MACHINE		
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; LOCATING PIN		
DWG NO.	TOOL# (see chart)-15	
		REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $XXX \pm .005$ FRACTIONS $\pm 1/32$ $XX \pm .01$ ANGLES $\pm .5^\circ$ $X \pm .1$		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE	NTS	DATE 5-1-08
		SHEET 9 of 9



OTES

1. BREAK ALL SHARP CORNERS (.015/.03).

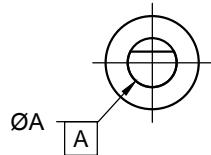
 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; SECONDARY SEAT	
DWG NO. TOOL# (see chart)-13	
REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS	
$XXX \pm .005$	FRACTIONS $\pm 1/32$
$XX \pm .01$	ANGLES $\pm 5^\circ$
$X \pm .1$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times .45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT	
FINISH SPEC	
$BLACK OXIDE$	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	5-1-08
SHEET 8 of 9	



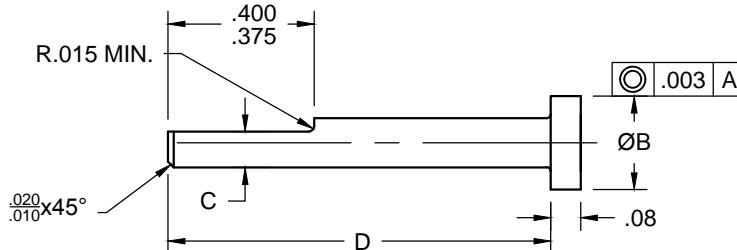
-11
**PRIMARY
SEAT**

NOTES

 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; PRIMARY SEAT	
DWG NO. TOOL# (see chart)-11 REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	5-1-08
 SHEET	7 of 9



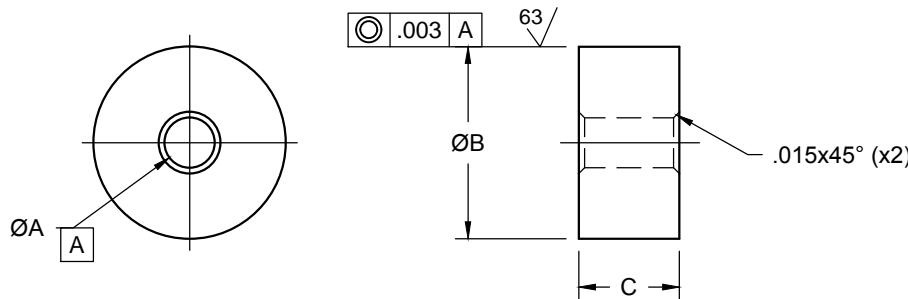
-9
PIN



NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; PIN	
DWG NO. TOOL# (see chart)-9 REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS	
$XXX \pm .005$	FRACTIONS $\pm 1/32$
$.XX \pm .01$	ANGLES $\pm .5^\circ$
$X \pm .1$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
SCALE	NTS
DATE	5-1-08
SHEET 6 of 9	



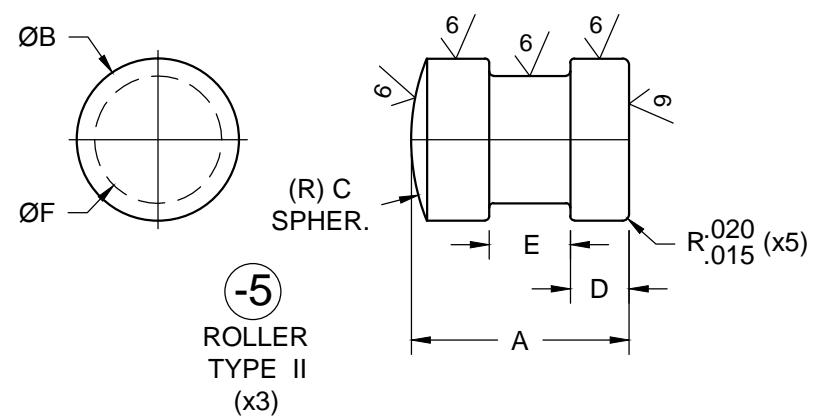
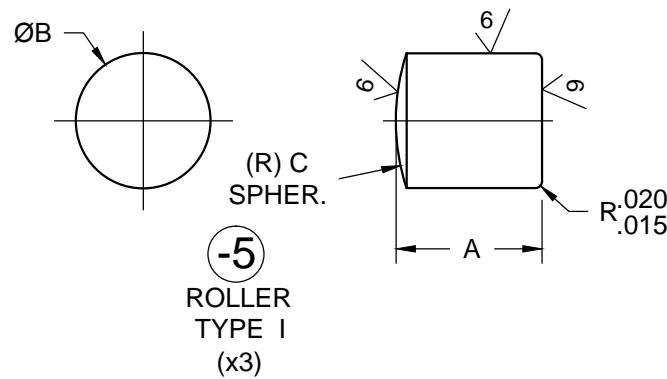
-7

GUIDE

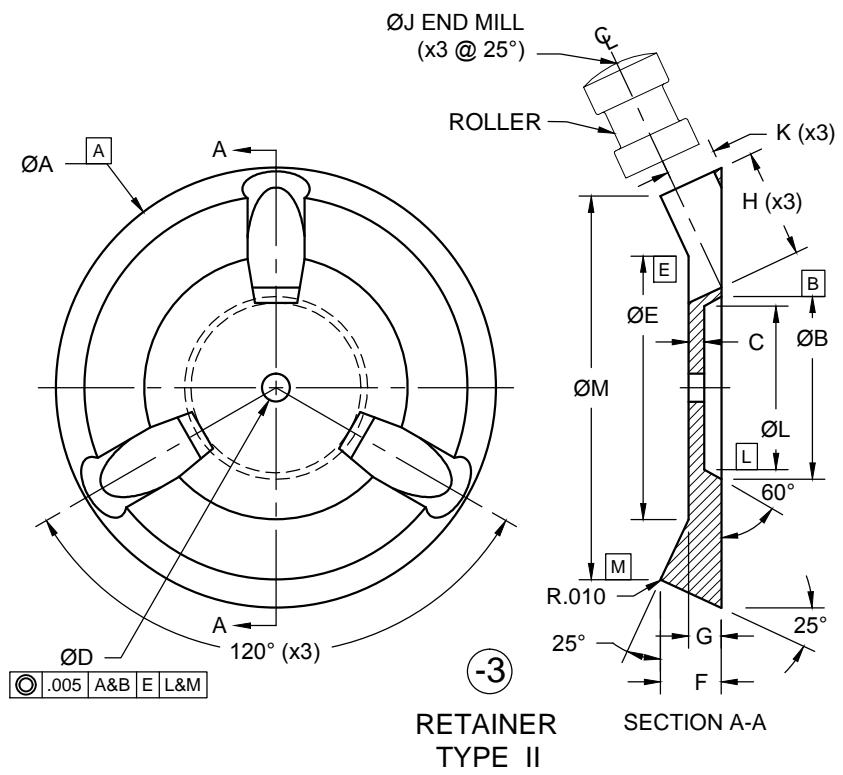
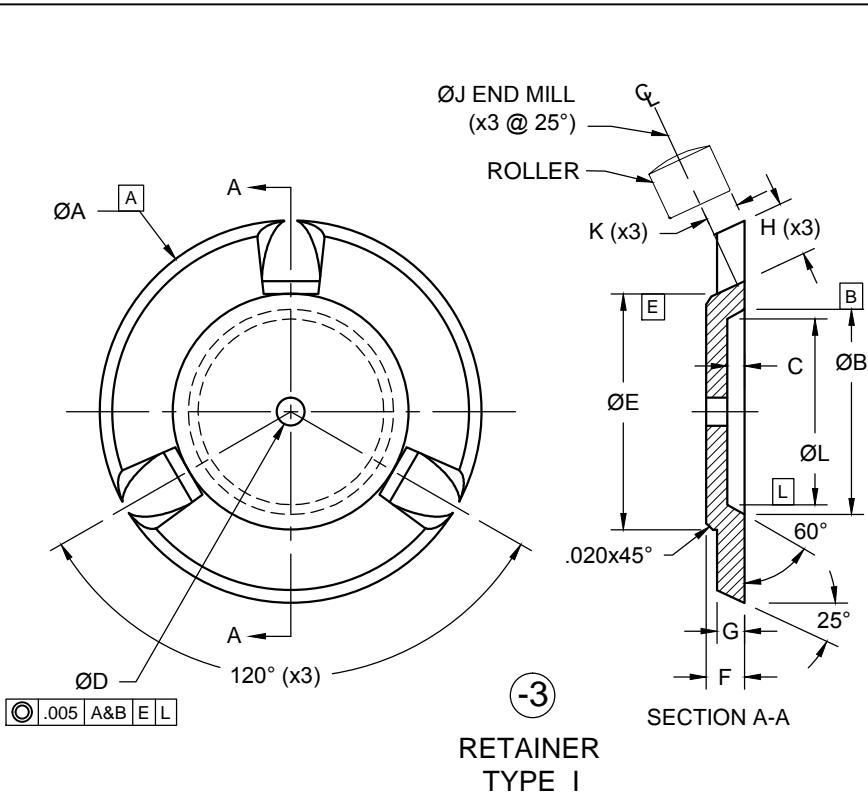
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; GUIDE	
DWG NO.	REV 2
TOOL# (see chart)-7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS $.XXX \pm .005$ FRACTIONS $\pm 1/32$ $.XX \pm .01$ ANGLES $\pm .5^\circ$ $.X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times .45^\circ$ PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON BEARING SEE Pg. 1	
SCALE	NTS
DATE	5-1-08
SHEET 5 of 9	



 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3)	
DWG NO. TOOL# (see chart)-5	
REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS $XXX \pm .005$ FRACTIONS $\pm 1/32$ $XX \pm .01$ ANGLES $\pm .5^\circ$ $X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times .45^\circ$ PR. $.015$ R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON BEARING SEE Pg. 1	
SCALE	NTS
DATE	5-1-08
 SHEET 4 of 9	



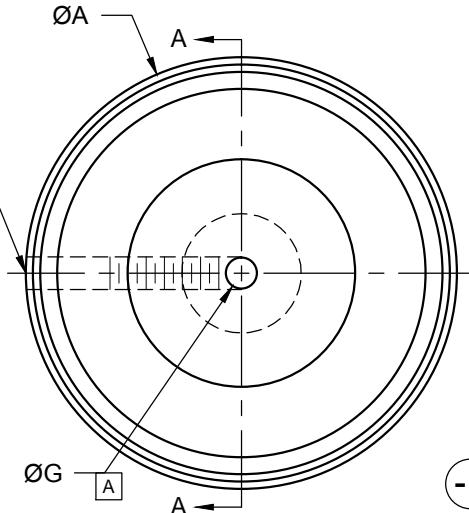
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

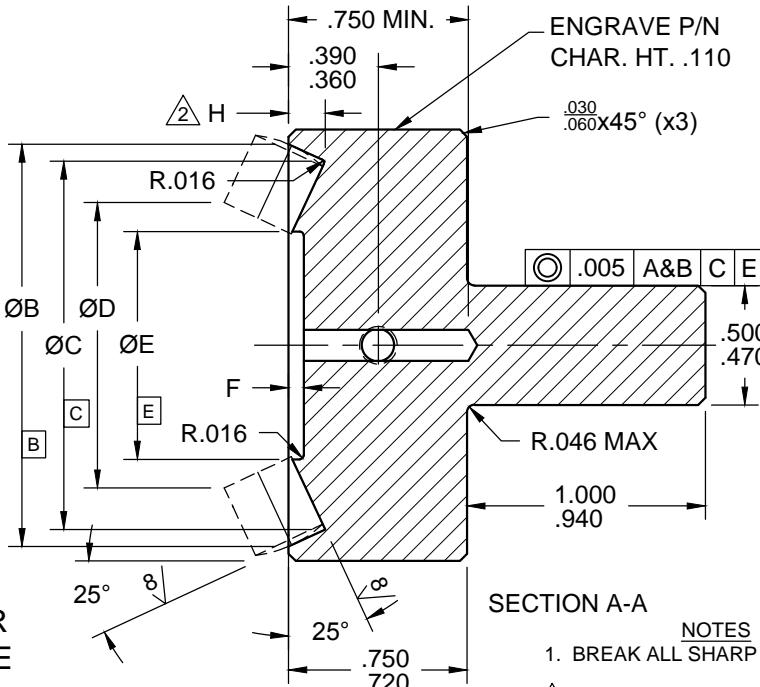
 RED BARN MACHINE	
TITLE	RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; RETAINER
DWG NO.	T-001 (see chart)-3
REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $XXX \pm .005$ FRACTIONS $\pm 1/32$ $XX \pm .01$ ANGLES $\pm 5^\circ$ $X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON BEARING SEE Pg. 1	
SCALE	NTS
DATE	5-1-08
SHEET 3 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-1 CH'D TOL. (H) WAS +/- .002 IS +/- .005.	6/17/13	BIM	GE

#8-32 UNC THRD
LENGTH 3/8 MIN.
C-BORE Ø.187
DEPTH OPTIONAL



ROLLER FIXTURE

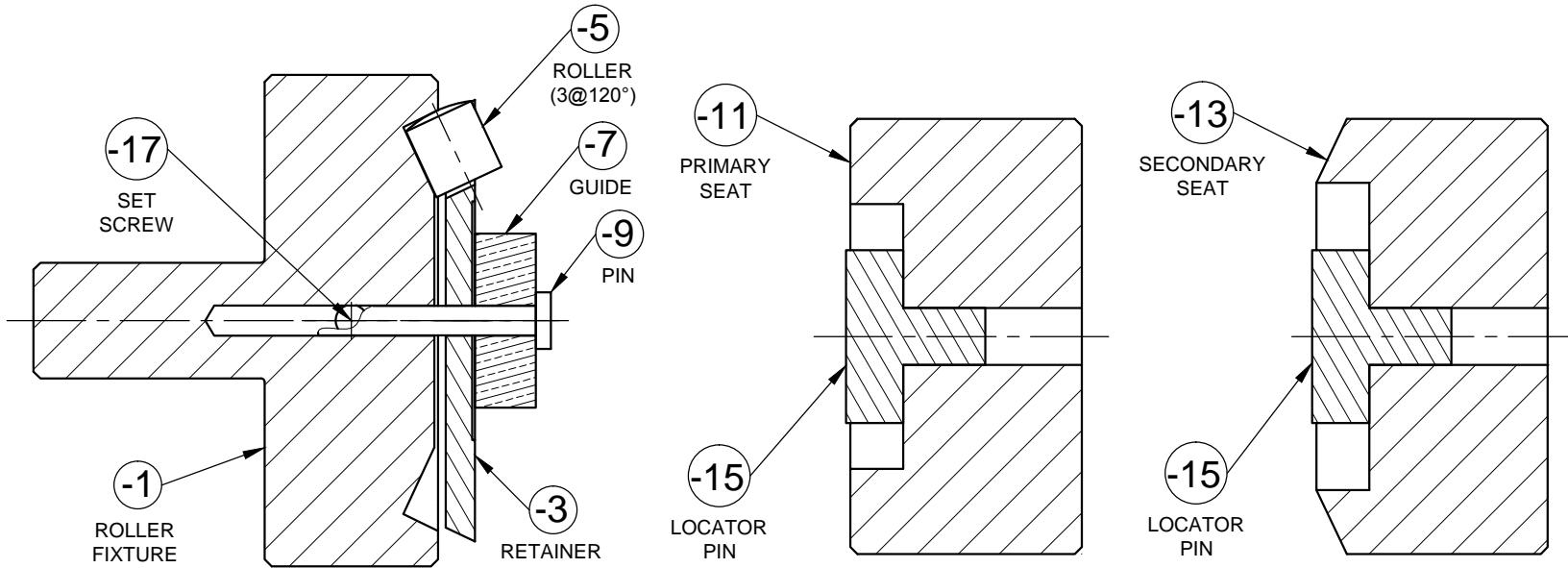


SECTION A-A

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).
2. DIMENSION TO BOTTOM OF R.016 = H DIM.;
DIMENSION TO SHARP CORNER= H DIM.+.005.
3. -1 BEARING RACE SURFACES MUST HAVE
SMOOTH APPEARANCE, FREE FROM
MACHINING MARKS AND GROOVES.
4. DO FIRST ARTICLE INSPECTION
BEFORE HEAT TREATING.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED -5 ROLLER RADUIS FROM .005 - .010, TO .015 - .020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
1A	CH'D T/N'S FROM KST.	11/20/09	RJC	
2	-1 CH'D TOL (H) WAS +/- .002 IS +/- .005.	6/17/13	BIM	GE



NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS
		-1	1	ROLLER FIXTURE	SEE CHART
		-3	1	RETAINER	SEE CHART
		-5	3	ROLLER	SEE CHART
		-7	1	GUIDE	SEE CHART
		-9	1	PIN	SEE CHART
		-11	1	PRIMARY SEAT	SEE CHART
		-13	0 or 1	SECONDARY SEAT	SEE CHART
		-15	1 or 2	LOCATING PIN	SEE CHART
B/O		-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4

 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOLS	
DWG NO. TOOL # (SEE CHART ABOVE) REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $XXX \pm .005$ FRACTIONS $\pm 1/32$ $XX \pm .01$ ANGLES $\pm 5^\circ$ $X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT LISTED PER ITEM FINISH SPEC LISTED PER ITEM USED ON BEARING SEE ABOVE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	5-1-08
SHEET 1 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPR
—	—	—	—	—

REVISIONS					
REV	DESCRIPTION	2100	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL. OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.		2/11/08	WP	DW
2	CHANGED -15 LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. CHANGED -11 & -13 FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.		2/19/08	WP	G.E.
3	ADDED KST2128 & KST2162. REMOVED 25 ANGLE FROM -13 SECONDARY SEAT AND DELETED ØB DIMENSION. ALSO ADDED QTY. TO -13 & -15 CHART.		4/22/08	WP	

REVISIONS					
REV	DESCRIPTION	2000	DATE	INITIAL	APPROVED
1	ADDED TOOL No.'s KST2014 & 2015 & 2017. ALSO ADDED -1 AUX. VIEW & ASSOCIATED DIMENSIONS WITH "J" DIM., CHANGING FROM .153 TO VARIABLE, -3 TYPE II RETAINER & ASSOCIATED DIMENSIONS, -5 TYPE II ROLLER & ASSOCIATED DIMENSIONS, AND VARIABLE QUANTITY TO -13 & -15 PER TOOL.		4/25/08	WP	DW

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS
			-1	1	RND	6061	Ø8-1/4 x 3-7/8
ASSY #							

 RED BARN MACHINE	
TITLE	
— —	
DWG NO.	
— —	
RE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:	
DECIMALS XXX \pm .005 FRACTIONS \pm 1/32 XX \pm .01 ANGLES \pm 5° X \pm .1	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
USED ON MODEL	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	8-15-07
SHEET	1 of

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	TITLE RED BARN MACHINE
CHECKED	
HEAT	
TREAT	
FINISH SPEC	
USED ON MODEL ?	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX \pm .005 FRACTIONS \pm 1/32 .XX \pm .01 ANGLES \pm 5° .X \pm .1
DWG NO.	PART #
SCALE NTS	DATE 1-28-06
REV.	SHEET 1 of 1